



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3640-1

Job Sheet 193707



Part No: D3640-1

Job Qty: 16 pcs

Part Name: Belt Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs	5/15/19	5/15/19	0.00	0.40	Bandsaw - 1	52	18/05/30
110	HAAS 4 Axis - B4B	16 pcs	5/15/19	5/15/19	0.33	4.97	HAAS - 1 - B4B	2	19/05/30
							HAAS - 2 - B4B	39	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	16 pcs	5/15/19	5/15/19	0.00	0.00	QC 8 - 12		19/05/31
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	16 pcs	5/15/19	5/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



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Container No: S185352



Part: D3640-1

Job No: 193707

Serial No/Batch: S185352

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/30/19

MDELRLINBO.750X1.000
M134641

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 5046
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAG
150 QC 21 - SA	16 pcs	5/15/19	0.00 0.00	QC 21 - SA - 21	21	JUN 05 2019
				QC 21 - SA - 70	9-55	
				QC 21 - SA - 53		

Part Op **100** - (Bandsaw) Cut blank 4.700 " long
 Descriptions: **110** - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA670 & Dwg D3640 Rev: A 2-Deburr and Blend rad intersection with deburring tool.
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____)
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB0.750X1.250	Delrin Bar	6.4000 ft (.4 ea)	100-Bandsaw - 1	7134641

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRLNB0.750X1.250	6	51	0

MAT
used
6.333'
SCRAP
0.291'

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Belt Guide	4.500Inches $\pm$ 0.030	4.530 4.470	4.501	
2	Belt Guide	0.800Inches $\pm$ 0.030	0.830 0.770	0.803	
3	Belt Guide	0.130Inches $\pm$ 0.030	0.160 0.100	0.120	
4	Belt Guide	0.310Inches $\pm$ 0.030	0.340 0.280	0.320	
5	Belt Guide	0.200Inches $\pm$ 0.010	0.210 0.190	0.200	
6	Belt Guide	0.400Inches $\pm$ 0.030	0.430 0.370	0.400	
7	Belt Guide	0.030Inches $\pm$ 0.030	0.060 0.000	0.028	
8	Belt Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	Angle
9	Belt Guide	0.230Inches $\pm$ 0.030	0.260 0.200	0.236	
10	Belt Guide	0.400Inches $\pm$ 0.030	0.430 0.370	0.400	
11	Belt Guide	0.625Inches $\pm$ 0.010	0.635 0.615	0.629	
12	Belt Guide	0.130Inches $\pm$ 0.030	0.160 0.100	0.125	Radius

DAS
73
9-89

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					